

Work Order ID 61674

Tuesday, August 31, 2010 10:45:58 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 8/31/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3537	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

BS 10-9-7

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(17)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

BS 10-9-7

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

0.00

S10/09/10

+17

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61674

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Page 2

Item ID: D3537-3

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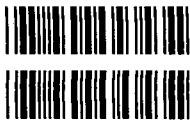
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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

0.00

Brake NC

Brake NC

Memo

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

(17)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

Ensure joggle as per dwg D3429

S.10.09.109

(X17)

150



Large Fab

Large Fab

0.00

Memo

Qty Description Batch A/R 2059B Hardcoat

M145879 Weld hardcoat as per Dwg D3437

SM 10/10/25 (7x)

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Work Order ID 61674

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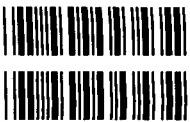
Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 8/31/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC10- Inspect visual per QSI004- ground welds

0.00

S101w125

QC

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

S101w125

QC

Quality Control

180



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 1125D8

Memo

0.00

17

8/10-10-27

Powdercoat

Powder Coating

START TIME:

2:00

OVEN TEMPERATURE:

320

FINISH TIME:

2:30

W/O:		WORK ORDER CHANGES					
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Start



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Item Name: Wearpad

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Start Date: 8/31/2010 Start Qty: 12.00



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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC3- Inspect Part Finish

QC

Quality Control

200



Identify as per dwg & Stock Location:

FL-17.

Packaging

Packaging

Memo

0.00

17 FL 10-10-27

210



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/10/28 JF

mf

10-10-27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 10:46:03 AM

Page 1

Work Order ID: 61674



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	82.9000	0.149	1.882105	2.5		1310-9-7

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT20	82.9	
115440	82.9	115440

(17)

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DART AEROSPACE LTD	Work Order:	6674
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-9-17	Date:	10/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
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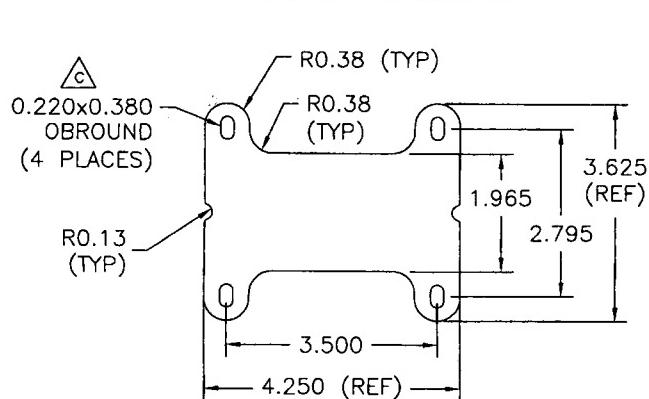
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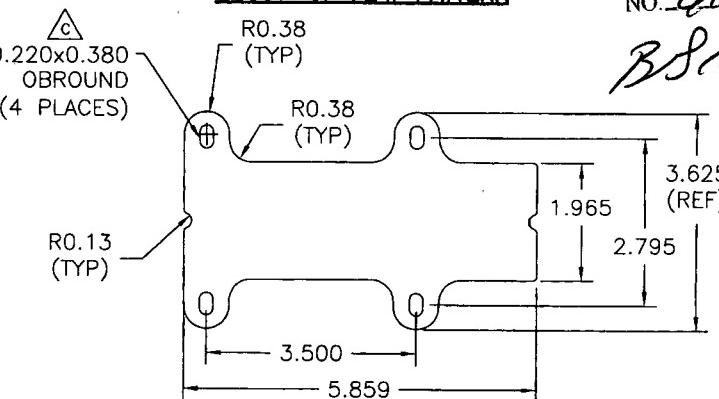
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 61079
B80-8-31

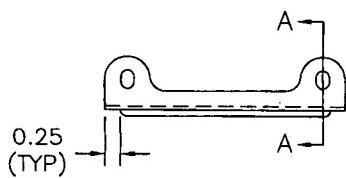
D3537-1F FLAT PATTERN



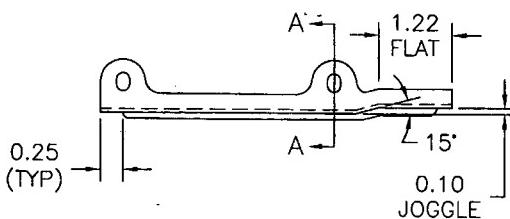
D3537-3F FLAT PATTERN



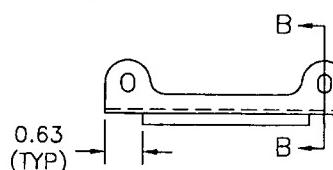
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HANCOCK, MA	
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN	
B	07.03.20	ADD AMS 5513 AND AMS 5524	
A	06.11.06	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Initials]</i>	<i>[Initials]</i>	D3537	SHEET 1 OF 1
DATE	07.04.13	TITLE	SCALE
		WEARPAD	1:2

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